2ේ Um:

Each

: GUIDE

: D31373

: N/A

: D3137 REV_B

: 30/05/2008

Date: User: Friday, 23/05/2008 9:56:58 AM

Julie Lecocq

Process Sheet

Drawing Name

Part Number

Material

Due Date

Description:

Drawing Number

Project Number

Drawing Revision

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 39449 : 11073

Estimate Number

P.O. Number

Prsht Rev.

First Issue

This Issue : 23/05/2008

: NC

: 11

Type

S.O. No. :

: MACHINED PARTS

: 37657

Previous Run

Written By

Checked & Approved By

Comment

: Est Rev:A 02.05.29

New Issue NG

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Delrin Bar

1.0

2.0

3.0

MDELRINB075X1250

Comment: Qty.: 0.0831 f(s)/Unit Total: 1.6611 f(s)

> Matl:Black Delrin bar 1.250" x .750" (ref DART spec. M-DELRIN-B) M14535

Batch: BAND SAW

Comment: BAND SAW

Cut Blanks.Blank size: 1.250" x .750" x .950" long

HAAS1

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA242 & Dwg D3137

2-Deburr

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

	-								
W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHA	NGE	By Date Qty Appro				Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	\ :	Date:	
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a	Section Section	on C	Chief Eng	QC Inspector
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Date:

Friday, 23/05/2008 9:56:58 AM

User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 39449

Part Number: D31373

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 38

FINAL INSPECTION/W/O RELEASE



7.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



	P								
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			·	•	QA: N	/C Closed	:	Date:	
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DATE	STEP	Description of NC		Corrective Action Section		Verifica	ation	Approval	Approval
DATE		STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Section C	Chief Eng	QC Inspector
									

DART AEROSPACE LTD	Work Order: 39440				
Description: Guide	Part Number: D313	7-3			
Inspection Dwg: D3137 Rev: E	Page 1	of 1			

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototy	ре
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Drawing	T -1	Actual	Accept	Baiast	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
0.175	+/-0.010	.176				
Ø0.257	+0.005/-0.000	.258				
Ø0.65 x 100°	+/-0.030	-665				
0.425	+/-0.010	.425				
0.550	+/-0.010	.550				
1.100	+/-0.010	1-102				
0.470	+/-0.010	.475				
0.850	+/-0.010	. 852	/			
0.143	+/-0.010	-143				
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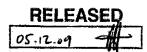
Measured by:	J.L.	Audited by:	Prototype Approval:	N/A
Date:	08/06/24	Date: 08/06/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.11.27	New Issue	KJ/RF	
В	04.11.12	0.175 was 0.145 & Ø0.65 x 100° was Ø0.75 x 100°	KJ/JLM LA	1
C	06.03.15	Dwg Rev update	KJ/JLM O	

W /O:			WC	ORK ORDER CHAN	IGES				
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DATE	STEP	Description of NC			ection B	Verifi	cation	Approval	Approval
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1	#	1	D3137 SHEET 1 OF
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05.1	1.23		BRACKET ASSEMBLY 1:
А		02.04.17	NEW ISSUE
В		03.01.16	ADD RIDGES; ADD MAT'L PROP.
С		03.08.15	ADD -043
D		04.11.03	RE-DESIGN D3137-5; CHANGE DIMS
Ε		05.11.23	ADD -045



MS24694-S101 SCREW
D3137-5 WASHER
D3137-3 GUIDE
INSTALL ON SAME SIDE AS C'SINKS
(OPPOSITE SIDE FROM RIDGES)

D3137-041 BRACKET ASSEMBLY (SHOWN)
D3137-043 BRACKET ASSEMBLY (SIMILAR)
D3137-045 BRACKET ASSEMBLY (SIMILAR)

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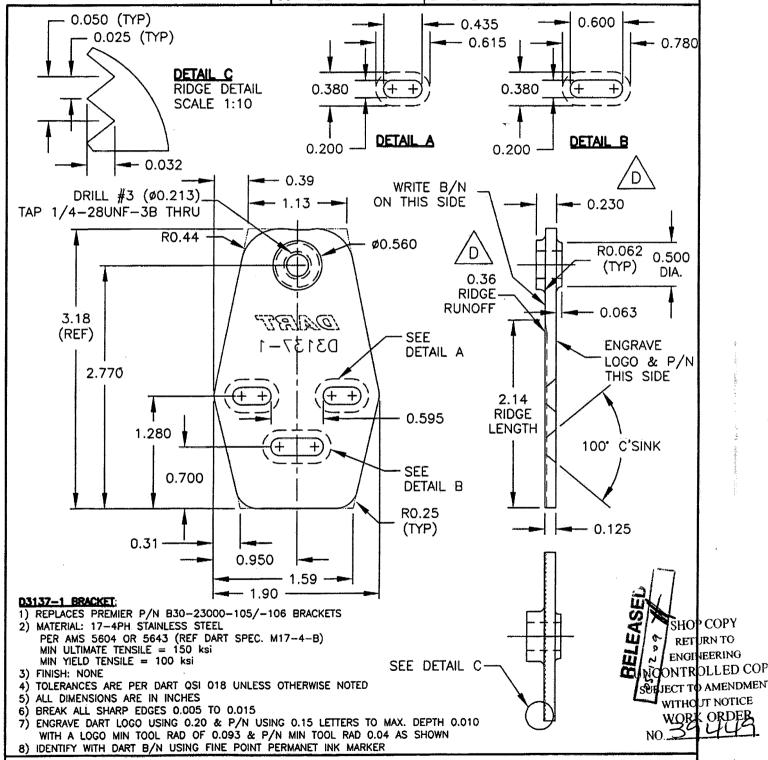
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DATE	SIEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Section C	Chief Eng	QC Inspector
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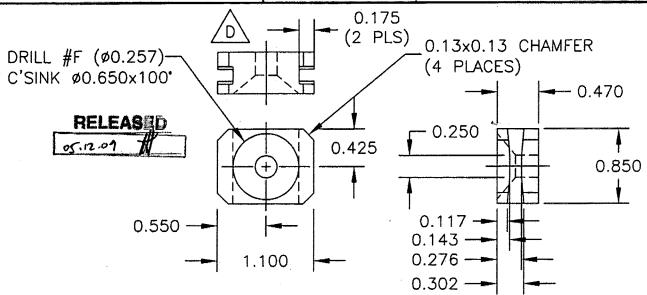
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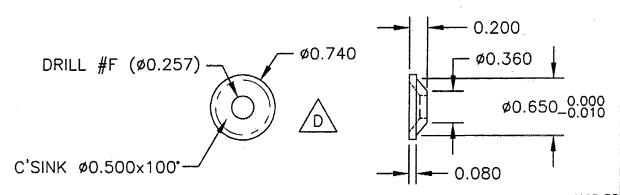


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05.11.23		BRACKET	ASSEMBLY	1:1



D3137-3 GUIDE

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015



D3137-5 WASHER

1) REPLACES PREMIER P/N B30-23000-209

SHOP COPY

RETURN ENGINEER NO

- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M60AJJ6R) ROLLED COPY 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WITHOUT NOTICE

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL EDGES 0.005 TO 0.015

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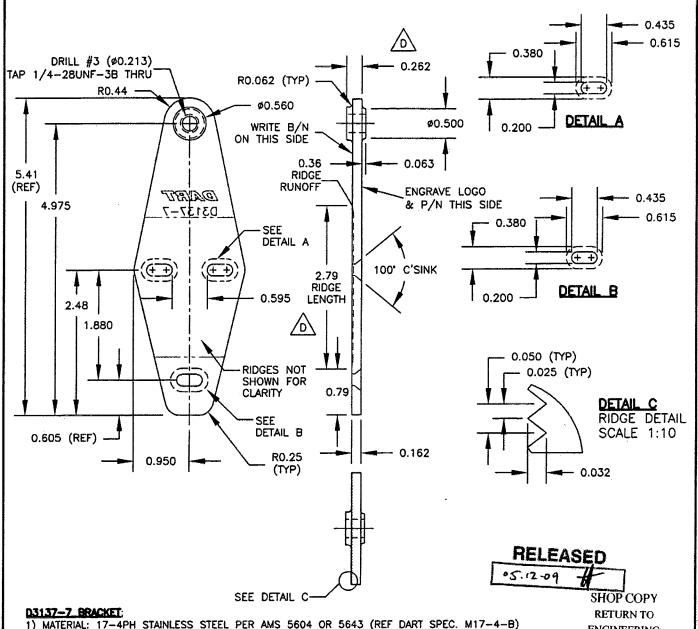
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Part No:	_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C C	losed:	Date:

NCR:			WORK ORDE	ER NON-CONFORMANO	CE (NCR)			
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 		D3137	SHEET 4 OF 5
DATE		TITLE	SCALE
05.11.23		BRACKET ASSEMBLY	2:3



1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi

2) FINISH: NONE

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010 WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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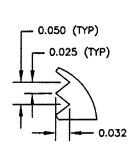
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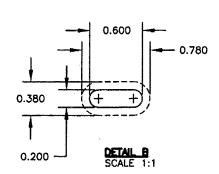


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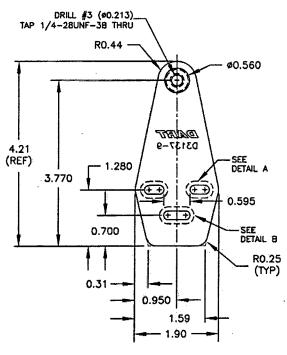
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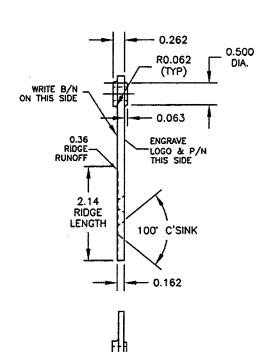


0.435 0.380 DETAIL 0.200



DETAIL C RIDGE DETAIL SCALE 1:20





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- D3137-9 BRACKET:

 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS

 2) MATERIAL: 17-4PH STAINLESS STEEL

 PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)

 MIN VIELD TENSILE = 150 ksi

 MIN YELD TENSILE = 100 ksi
- 3) FINISH: NONE
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES 0.005 TO 0.015
- ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010 WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- B) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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DATE	STEP	PR	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA:	Date: _	-
					QA: N	C Closed:	Date: _	
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D.47=		Description of NC		Corrective Action Section	on B	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

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